

Work Order ID 61846

Tuesday, September 07, 2010 3:38:10 PM



Page 1

Item ID: D3578-041

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/7/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-9-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3578	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3578 (Run prog. D3578-1) ☐ Dwg Rev: A ☐ Prog

Rev: A ☐ 2-Deburr if necessary

6061 . 080



10-9-15

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-9-15

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Solorio

counted
432

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Doubler

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Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

0.00

Memo

0.00

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

9/10/09/20 32

32

8/10/09/20

all 10/09/20

32

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 10-9-21.

32

0

Memo

0.00

170



Small Fab

Small Fab

Small Fab

Memo

1-Assemble as per dwg D3578

0.00

0.00

9/10/09/21 *32*

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8/10/09/21

count
x32

Memo

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 9/7/2010 Start Qty: 30.00

Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 2470

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Cc 10/5/10 32

10/09/22 MF 10-9-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 07, 2010 3:38:14 PM

Page 1

Work Order ID: 61846

Parent Item: D3578-041

Parent Item Name: Doubler

Start Date: 9/7/2010

Required Date: 9/13/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: A ☐ 07.04.11 ☐ New issue ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3569 Decal	<i>NA for shoulder harness</i> ②	Manufactured	No			110	Each	22.0000	1	30			
<i>Remove</i>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST245A				22					
				32084				22					
MS20426AD3-3 Rivet		Purchased	No			110	Each	5,021.000	2	60			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				5021					
				19099				4774					
				7681				247					
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			170	sf	0.3512	0.007	0.221053			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT21				0.3512					
				113438				0.3512					
MS21075L3 Nutplate		Purchased	No			170	Each	82.0000	1	30			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST303				82					
				113734				1					
				114760				81					

ES 10/09/21

62

1810-9-15

113438

ES 10/09/21

32

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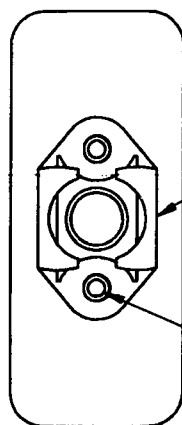
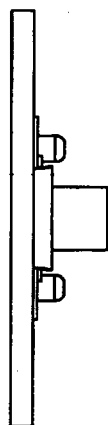
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12	TITLE DOUBLER		SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



D3578-1 PLATE

MS21075L3 NUT PLATE

MS20426AD3-3 RIVET
(2 PLACES)**RELEASED**
07.04.02**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER**D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

SHOP COPY

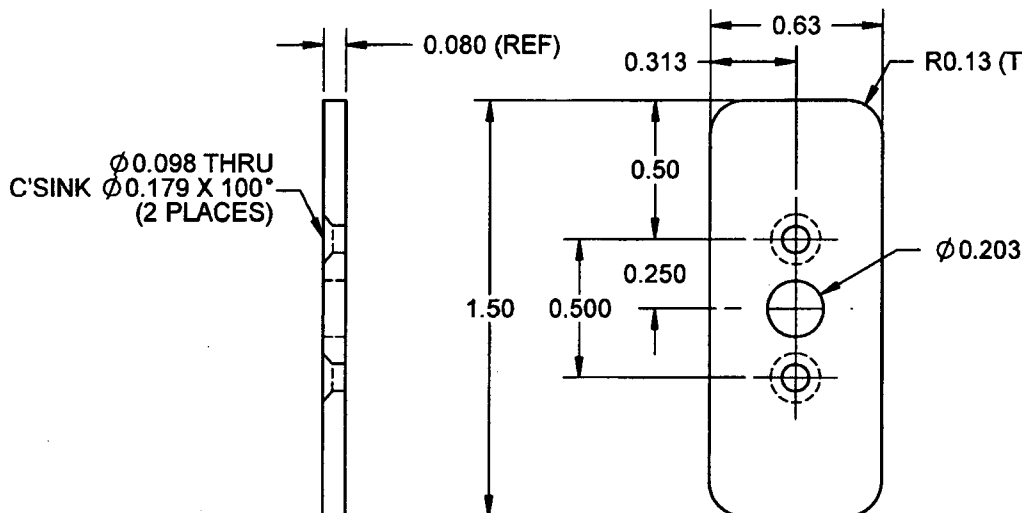
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

R0.13 (TYP) WORK ORDER

NO. *61846**D10-9-08***D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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